التيم مياهيون الدر مان الدي	
-	
Work Order ID	715

597



Page 1

Wednesday, July 06, 2011 1:28:19 PM Item ID:

D3201-1

Revision ID:

Item Name: Doubler

7/6/2011 **Start Date:** Required Date: 7/20/2011 Start Qty: 12.00

Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Sequence ID/

Work Center ID

Process Plan:

Date: (1/07/06 Tooling:

Date:

0.00

0.00

0.00

0.00

Accept

Set Up/

Run Hours

SPC (Y/N):

__□Prog Rev: |

Tool ID

Tool # Plan

Date:

Date:

Accept Qty

Code

Reject **Qty**

Reject Number

Draw Nbr

D3201 Rev B

100

Waterjet

110

OC

120

FLOW CNC Waterjet

740. 4626

Description **Revision Nbr**

Operation

FLOW WATER JET

Memo

1-Cut as per Dwg D3201 Dwg Rev: 🎗

Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

QC8- Inspect parts - second check

S w/08/15

Run

Start

Stop

Setup Start

Stop

Insp.

Stamp

AB11-8-15

B11-8-15

counter

Quality Control

Quality Control

QC

Memo

		•							
W/O:			WC	RK ORDER CHANG	ES	· ·			
DATE	STEP	PROC	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						4			
						·			
	ŕ								
						•			
Part No	:	PAR #:	Fault Category: NC			No DQ	Date:		
	Reso	olution:	Dispositio);	_ QA: N/C C	losed:		Date: _	
NCR:		W	ORK ORDI	ER NON-CONFORMA	NCE (NCF	R)		,	
DATE	STEP	Description of NC			Section B Verifica			ation Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign a		on C	Chief Eng	QC Inspector
		Υ							
								1	
					•				

Work Order ID 71597

Page 2

Item ID:

D3201-1

Wednesday, July 06, 2011 1:28:19 PM

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Doubler

7/6/2011

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Date:

Tooling:

Date:

Run

Accept

Qty

Start

Required Date: 7/20/2011

Date: _____

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Reject

Qty

Insp.

Stamp

Sequence ID/ **Work Center ID**

130

Small Fab

Small Fab

Operation Description

Small Fab

Chemical Conversion Coat per QSI005 4.1

Set Up/ Run Hours

0.00

140

HandFinish Hand Finishing

Memo

0.00

0.00

Reject

Number

150

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

W/O:			WO	RK ORDER CHANGI	ES				
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	Date: _	W- H
	Res	solution:	Disposition: QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	1)			
DATE	STEP	Description of NC					cation		Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
								ŧ	

Work Order ID 71597

Wednesday, July 06, 2011 1:28:19 PM



Page 3

Item ID:

D3201-1

Accept



Setup Start



Revision ID:

Item Name:

Doubler

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Memo

Memo

Date:

Tooling: SPC (Y/N):

Set Up/

Run Hours

Date: Date: Run

Start

Stop

Stop



Sequence ID/

Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Date:

0.00

Tool ID

Tool # Plan Code Accept Oty

Reject

Reject Insp. Number

Stamp

0.00

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

VII. 08-14

	oopaoc								
W/O:			W	ORK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·			-					t
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _	<u> </u>
	R	esolution:	Disposition: QA			QA: N/C Closed:			
NCR:		V	VORK ORE	DER NON-CONFORMA	NCE (NCR)	<u> </u>		* ************************************
DATE	STEP	Description of NC		Corrective Action Section B			cation	Approval A	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
	ļ ļ								
		·							:

Picklist Print

Wednesday, July 06, 2011 1:28:17 PM

Work Order ID: 71597

Parent Item:

D3201-1

Parent Item Name: Doubler



Start Date: 7/6/2011

Required Date: 7/20/2011

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

Removed from 9 Digit 06-01-25 JLM

Now on Waterjet IPP Rev:B

06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	202.5684	0.276	3.486316	0,		

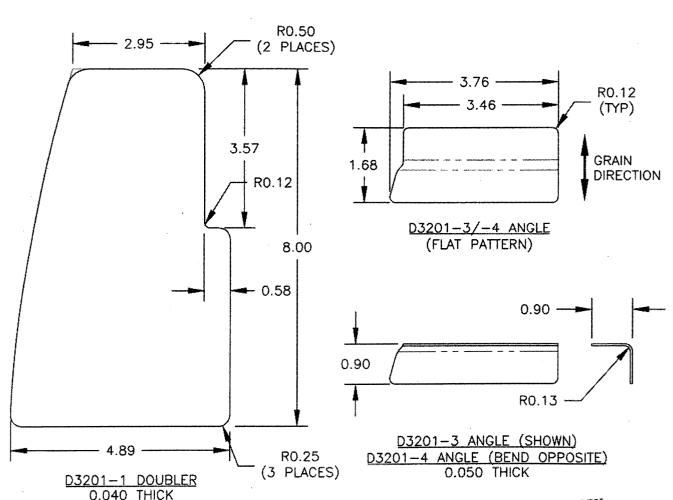
Location	Loc Qty	Loc Code	63
MAT022	202.568421		$\underline{}$. ($\mathcal{L}\mathcal{L}_{i}$
112291	0.5		
112331	0.7		
113162	18.1		
117684	183,268421		117697

Dai t Aci	ospace	Elu								
W/O:			W	ORK ORDER CHANG	GES					· • · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
==-									<u>. </u>	
Part No	·	PAR #:	Fault Ca	tegory:	NCR:	Yes N	o DQ	A :	_ Date: _	
•	Resolution:			ion:	QA: N	VC Clos	sed:		Date: _	
NCR:			WORK OR	DER NON-CONFORM	ANCE ((NCR)				
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Desc		Section B Sign				Approval Chief Eng	Approval QC Inspector
			Chief Eng	Chief Eng		Date				
		·								
·										
]	





DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	ED	APPROVED	DRAWING NO. REV. B
-	-#-	H	D3201 SHEET 1 OF 1
DATE			TITLE SCALE
03.1	1.03		DOUBLER 1:2
 Α		03.08.07	NEW ISSUE
В		03.11,03	MODIFY D3201-1, ADD D3201-3/-4



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4) (REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO 71597 CL11107106

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DART AEROSPACE LTD	Work Order:	7/597
Descriptions Doubles	Part Number:	D3201-1
Description: Doubler	Part Number.	D3201-1
Inspection Dwg: D3201 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST									
		X First A	rticle [Prof	totype				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments			
R0.50	+/-0.030	,50	10		R.G				
3.57	+/-0.030	3.568	8		V BOZ				
R0.12	+/-0.030	-13	প্ত		RG				
8.00	+/-0.030	7.449	ک		V				
0.58	+/-0.030	,574	1		V				
4.89	+/-0.030	4.821	>		V				
R0.25	+/-0.030	76.	3		R.G				
0.040	+/-0.010	840.	7		V				
Weasured by:	B	Audited by	8		Prototype Approv	/al: N/A			

Measured by: 🖟	Audited by:	Prototype Approval:	N/A
Date: (1-2-13	Date: 1/08/15	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.11.28	New Issue	P/O D412-698-015	KJ/RF	
				; (1	• '